

holding said pipe in said cavity by insertion of said controlling member into at least one opening of said pipe or insertion of at least one end of said pipe in to a hole of said controlling member; and

pouring a molten aluminum alloy into said cavity so as to enclose said pipe with said aluminum alloy, wherein said pipe is free to move in an axial direction relative to said mold until said aluminum alloy hardens.

8. (Twice Amended) A method for production of aluminum cast product enclosing a pipe therein, which comprises the steps of:

coupling a bracket having a hole to a pipe;

arranging said pipe at a predetermined position in a cavity of a mold;

holding said pipe in said cavity by inserting a controlling pin, which extends through a wall of the mold to the said cavity, into said hole of said bracket; and

pouring a molten aluminum alloy into said cavity so as to enclose said pipe with said aluminum alloy, wherein said pipe is free to move in an axial direction relative to said mold until said aluminum alloy hardens.

17. (Once Amended) A method for manufacturing an aluminum cast product enclosing a pipe inserted therein, which comprises the steps of:

projecting a controlling member into a cavity of a mold;

arranging a pipe at a predetermined position in said cavity of said mold;

holding said pipe in said cavity by insertion of said controlling member into at least one opening of said pipe or insertion of at least one end of said pipe in to a hole of said controlling member; and

pouring a molten aluminum alloy into said cavity so as to enclose said pipe with said aluminum alloy, wherein said pipe is free to move in an axial direction relative to said mold until said aluminum alloy hardens; and

wherein said controlling member is configured to allow axial movement of said pipe without radial dislocation.

18. (Once Amended) A method for production of aluminum cast product enclosing a pipe therein, which comprises the steps of:

coupling a bracket having a hole to a pipe;

arranging said pipe at a predetermined position in a cavity of a mold;